

Work Order ID 85531

85531

Page 1

Item ID: D4030-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Long Basket Assembly (350)

Start Date: 08/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/11*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing	****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

1 *φ* *BLD-7.12*

Srloskiz

Q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

85531

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 08/06/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 22/06/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 Identify as per dwg & Stock Location:_____

0.00

130

Packaging

0.00

Packaging

140	QC21- Final Inspection - Work Order Release	0.00
-----	---	------

140

QC Memo

0.00

Quality Control

MLJ 12/07/12

mf
12-07/2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 85531

85531

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200 *D4086-200* Placard, Max Load		Manufactured	No				Each	15.0000		1			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST093				15					
				72051				1					
				82827				2					
				84416				12		84416			
D2530 *D2530* Handle Weldment		Manufactured	No			100	Each	4.0000	1	1			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST506				4					
				82895				1					
				83423				3					
D2535 *D2535* Spring		Manufactured	No			100	Each	67.0000	2	2			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST504				67					
				83545				67		83545			

JB 12/07/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 85531

85531

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2537 Manufactured No

100 Each 34.0000 2 2 ✓

D2537

Bushing

**

JB

Location

Loc Qty

Loc Code

ST504

34

82896

34

82896

D3913-041 Manufactured No

100 Each 0.0000 1 1

D3913-041

Long Basket Base Assembly, 350

**

1 BK 12-7-12

D3914-041 Manufactured No

100 Each 0.0000 1 1

D3914-041

Long Basket Lid Assembly (350)

**

1 BK 12-7-11

D3917-3 Manufactured No

100 Each 47.0000 6 6

D3917-3

Washer

**

85780 JB

Location

Loc Qty

Loc Code

FP

11

85028

11

ST070

36

84773

36

D3953-3 Manufactured No

100 Each 15.0000 2 2 ✓

D3953-3

Gas Spring Stud, Lid

**

85788 JB 12/07/11

Location

Loc Qty

Loc Code

ST075

15

82939

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 85531

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Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-7 Manufactured No

100 Each 25.0000 2 2 ✓

D3953-7

Spring Spacer

**

Location

Loc Qty

Loc Code

ST075

25

82940

25

82940

D3953-9 Manufactured No

100 Each 37.0000 2 2 ✓

D3953-9

Gas Spring Washer

**

Location

Loc Qty

Loc Code

ST075

37

82941

37

82941

D3953-17 Manufactured No

100 Each 19.0000 2 2 ✓

D3953-17

Gas Spring Spacer

**

Location

Loc Qty

Loc Code

ST075

19

82937

19

82937

D3953-19 Manufactured No

100 Each 36.0000 1 1 ✓

D3953-19

Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST075

36

82938

36

82938

D3953-21 Manufactured No

100 Each 1.0000 1 1 ✓

D3953-21

Gas Spring Bracket

**

Location

Loc Qty

Loc Code

ST075

1

81456

1

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 85531

85531

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No

100 Each 44.0000 1 1 ✓

D3969-3

Spring (Basket Lid)

**

JB

Location

Loc Qty

Loc Code

ST272

44

64285

1

81887

3

82942

40

82942

AN3-14A Purchased No

100 Each 73.0000 4 4 ✓

AN3-14A

Bolt

**

122141 JB

Location

Loc Qty

Loc Code

ST352

73

121444

23

121708

50

12

AN3-16A Purchased No

100 Each 113.0000 2 2 ✓

AN3-16A

Bolt

**

JB 12/07/11

Location

Loc Qty

Loc Code

ST352

113

117441

47

118628

1

120986

15

121708

50

1x 120986
1x 121708

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

Work Order ID: 85531

85531

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-17A

Purchased

No

100

Each

68.0000

4

4

✓

AN5-17A

Bolt

**

122151

JB

Location

Loc Qty

Loc Code

338

4

121181

4

ST338

64

117872

34

121541

30

AN4-12

Purchased

No

100

Each

47.0000

3

3

✓

AN4-12

Bolt

**

JB

Location

Loc Qty

Loc Code

ST357

47

118626

1

121652

46

121652

AN310-4

Purchased

No

100

Each

128.0000

3

3

AN310-4

NUT

**

JB

12/07/11

Location

Loc Qty

Loc Code

ST344

128

120124

1

120518

1

121011

1

121349

25

121827

100

121827

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 6

Work Order ID: 85531

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

85531

D4030-041

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN310C4 Purchased No

100 Each 32.0000 2 2 ✓

AN310C4

Nut

**

122151 JB

Location

Loc Qty

Loc Code

ST344

32

120360

7

121166

3

121444

22

MS21042L3 Purchased No

100 Each 2,011.000 6 6 ✓

MS21042L3

Nut

**

JB

Location

Loc Qty

Loc Code

ST300

2011

115835

4

117885

32

119017

884

119075

138

121349

143

121444

810

MS21042L5 Purchased No

100 Each 1,381.000 4 4 ✓

MS21042L5

Nut

**

JB 12107/11

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

881

108827

4

116105

5

116548

43

117611

18

119109

795

17651

8

2937

8

119109

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 7

Work Order ID: 85531

85531

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

100

Each

194.0000

3

3

**

MS24665-151

Cotter Pin

Location

Loc Qty

Loc Code

ST309

194

17566

194

17566

MS24665-300

Purchased

No

100

Each

149.0000

2

2

**

MS24665-300

Cotter Pin

Location

Loc Qty

Loc Code

GA

145

118234

145

118234

ST309

4

116823

4

NAS1149F0432P

Purchased

No

100

Each

738.0000

6

6

**

NAS1149F0432P

Washer

Location

Loc Qty

Loc Code

ST275

738

121350

738

121350

NAS1149F0563P

Purchased

No

100

Each

968.0000

4

4

**

NAS1149F0563P

Washer

Location

Loc Qty

Loc Code

ST275

968

121350

968

121350

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

June-11-12 9:46:27 AM

Page 8

Work Order ID: 85531

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

85531

D4030-041

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

596.0000

8

8

✓

NAS1149F0332P

WASHER

JB

Location

Loc Qty

Loc Code

ST275

596

117735

13

119225

10

120986

200

121259

200

121584

9

121825

161

17317

3

120986

NAS1149C0432R

Purchased

No

100

Each

3,834.000

2

2

✓

NAS1149C0432R

Washer

JB 12/07/11

Location

Loc Qty

Loc Code

ST297

1070

117291

70

119124

1000

ST298

2764

121255

2764

121255

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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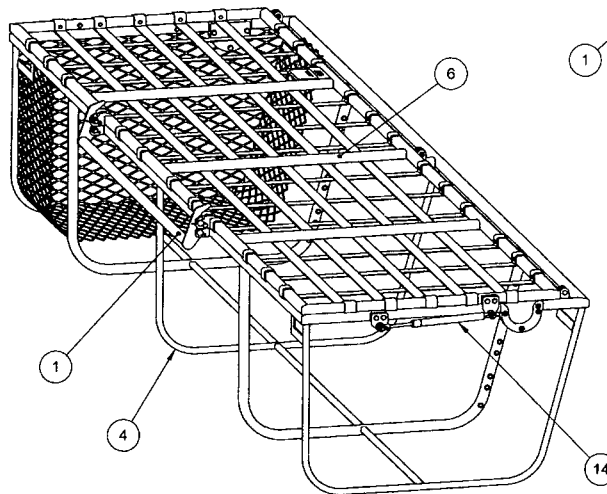
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET, LID ASSY. (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	C3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER

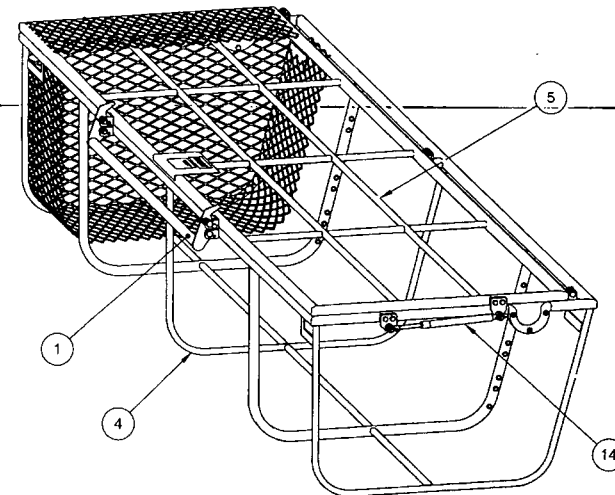
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85531 MCT
12/06/11

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-12-01
ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1). QTY FOR ITEM #3 WAS 4 (D6-1). ONLY 2 ARE REQUIRED. AFFECTS SECTION C-C (D3-3)	MB	10.07.23
B	ANS-21A BOLT WAS ANS-18A. BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.	JES	DRAWING NO. D4030	REV. C SHEET 1 OF 3
APPROVED	MB	TITLE	SCALE
DE APPR.	#	LONG BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

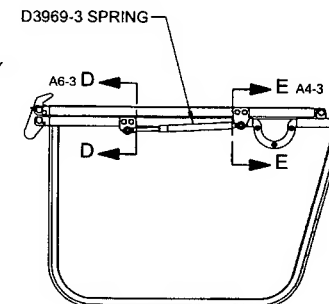
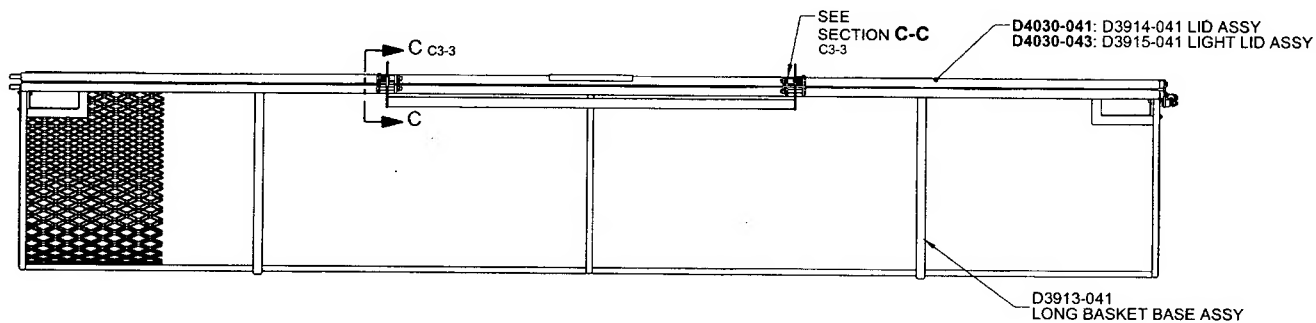
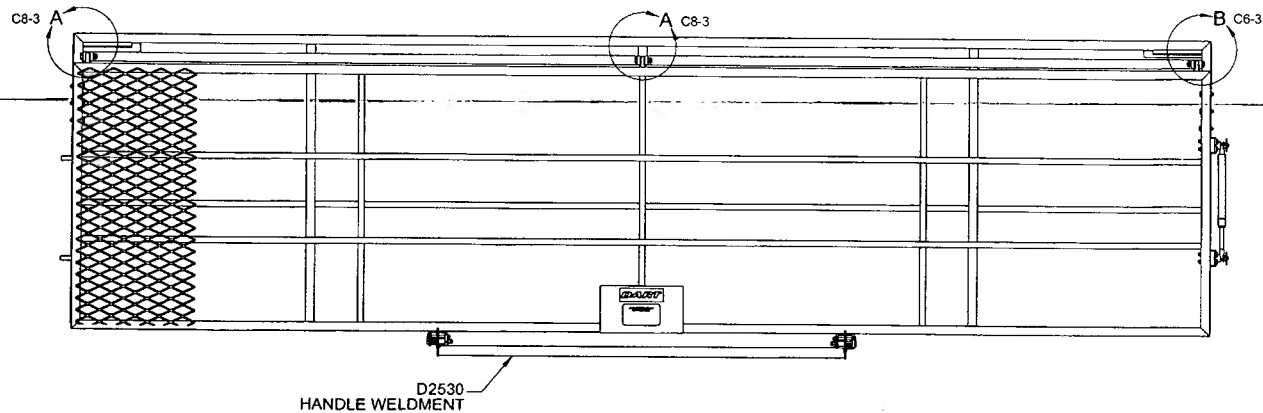
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12 CP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	SEB	D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	__ _ NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

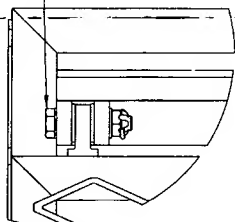
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

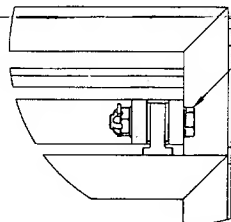
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



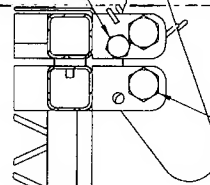
DETAIL A D8-2
D5-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



DETAIL B D3-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

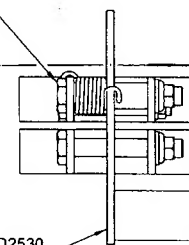


SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
10.08.12 4

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DE APPR.		LONG BASKET-ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries